

February-23-15 10:19:56 AM

129754

Page 1

Accept

N900040100

Setup Start *NS1*

Item Name: Fuel Scupper

Stop *NS2*

Start Date: 2/12/15 **Start Qty:** 2.00

?

Cust Item ID:

Required Date: 2/23/15 **Req'd Qty:** 2.00

~

Customer:

Reference:

Approvals: Process Plan: MCS Date: 1502-24

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-718	A		DAS 27 9-89						
100	Document Control	0.00						MLJ	1505-20
100	DOCUMENT CONTROL					2			(2)
DC	Memo	0.00	DAS 6 9-89						
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD206-718-011 CHG001					MAY 2 2 2015			
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00	DAS 6 9-89						
Quality Control						2			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129754***129754***

Page 2

Item ID: D206-718-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fuel Scupper

Stop ***NS2***

Start Date: 2/12/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-718-011

Location: 6124

2

DAS

MAY 29 2015 6 9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ

MAY 25 2015

MLJ

MAY 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
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Supplier									
Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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129754

D206-718-011

Required Date: 2/23/15

Required Qty: 2.00

Comments: IPP Rev: C Removed manufacturing 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
80-004-2-12 *80-004-2-12* Insert		Purchased	No			110	Each	8.0000	1	2		9-89	26-9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST563				8					
				m130547				8					
AN3H14A *AN3H14A* Bolt		Purchased	No			110	Each	225.0000	4	8		9-89	26-9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST349				225					
				120423				185					
				M129521				40					
D3270-041 *D3270-041* Fuel Scupper Assembly		Manufactured	No			110	Each	0.0000	1	2		9-89	26-9-89
D3271-1 *D3271-1* Gasket		Manufactured	No			110	Each	20.0000	1	2		9-89	26-9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST032				20					
				129390				20					

DQA: _____ Date: _____



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Doc/Data									
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Handling/Pre									
Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Page 2

Work Order ID: 129754

Parent Item: D206-718-011

Parent Item Name: Fuel Scupper

129754

D206-718-011

Start Date: 2/12/15

Required Date: 2/23/15

Start Qty: 2.00

Required Qty: 2.00

MS21919-DF6 MS21919WDF6 Purchased

No

110 Each

2.0000

1 2

MS21919-DF6

Clamp

*

DAS
6
9-89

Location

ST300

Loc Qty

2

Loc Code

m131624

m127304

2

110 Each

21.0000

1 2

MS27039-1-40

Purchased

No

MS27039-1-40

Screw

DAS
6
9-89

Location

ST284

Loc Qty

21

Loc Code

m127831

21

110 Each

2,335.000

1 2

NAS1149D0332J

Purchased

No

NAS1149D0332J

Washer

DAS
6
9-89

Location

CA

Loc Qty

14

Loc Code

m129682

14

ST269

2321

m132189

112794

16

m130325

1305

m131624

1000

110 Each

4.0000

1 2

NAS43DD3-128

Purchased

No

NAS43DD3-128

Spacer

DAS
6
9-89

Location

ST262

Loc Qty

4

Loc Code

123646

4

m132286

DAS
27
9-89
MAY 20 2015

DAS
26
9-89

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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DESIGN #	DRAWN BY A	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D206-718	REV. A SHEET 1 OF 1
DATE 04.02.23		TITLE FUEL SCUPPER	SCALE NTS
A	04.02.23	NEW ISSUE	

REFERENCE ONLY

DAS
6
9-99

Qty -011	Part No.	Description
X	D206-718-011	FUEL SCUPPER
1	D3270-041	FUEL SCUPPER ASSEMBLY (REPLACES ECM 32801-01)
1	D3271-1	GASKET (REPLACES ECM 32801-05)
1	80-004-2-12	INSERT
4	AN3H14A	BOLT
1	AN960JD10L	WASHER
1	MS219T9DF6	CLAMP
1	MS27039-1-40	SCREW
1	NAS43DD3-128	SPACER

GENERAL NOTES:

- 1) D206-718-011 REPLACES ECM 206-99216-1
- 2) INSTALL D206-718-011 KIT PER INST32801-04 REV. 0 (REF: DOCUMENT CONTROL LIST A-328-DCL1 REV. 0 PER CANADIAN STC SH99-216 & FAA STC SR01187NY)

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